

Work Order ID 79654

February-01-12 11:23:52 AM

\*79654\*

Page 1

Item ID: D206-642-341

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/01 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

*NA*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 79654

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February-01-12 11:23:52 AM

Item ID: D206-642-341

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
<b>*110*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/RAluminum Rod <u>M119785</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A,& B ) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

10 CF 12-2-14

10 CF 12-2-15

PTC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O: 791654		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-341 PAR #: \_\_\_\_\_ Fault Category: seal-tube NCR: Yes No DQA: CP Date: 12/03/28  
 Resolution: Use as is Disposition: Use as is QA: N/C Closed: CP Date: 12/3/28

NCR: 12-182		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-2-16	110	while removing rear inner inlet pipe ridge employees dis-rod dugard removed 100" instead of 0.75"	CP 12.02.16 PS/042	Acceptable	CP/DP 12-2-17	CP 12/3/27	CP 12.02.16 PS/042	CP 12/3/27
		RC; New, part time employee w/ lack of experience.	CP 12.02.16		CP/DP 12-2-17		CP 12.02.16	

NOTE: Date & initial all entries

# Work Order ID 79654

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February-01-12 11:23:52 AM

Item ID: D206-642-341

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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115 QC5- Inspect part completeness to step on W/O 0.00

**\*115\***

QC Memo 0.00

Quality Control

DP 12-2-17

120 Chemical Conversion Coat per QS1005 4.1 0.00

**\*120\***

HandFinish Memo 0.00

Hand Finishing

CF 12-2-17

125 QC3- Inspect Part Finish 0.00

**\*125\***

QC Memo 0.00

Quality Control

DP 12-2-17 PTC

W/O: 79654		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-2-17	120	Should read QC7  ALREADY DONE	DP	12-2-17				

Part No: D206-642-341 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D206-642-341

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.

cure time before cutting

Start Date: 12/2/17 Time: 10:30 1100

Finish Date: 12/2/17 Time: 12:00 9:00

A/RSikaflex-291 11/19999

Sikaflex expiry date: 12/08/13

① SAP 12-02-17

CF 122-17

140

QC5- Inspect part completeness to step on W/O 0.00

**\*140\***

QC

Quality Control

Memo

0.00

1 8 BE 12/02/2017



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

**\*150\***

Skidtubes

0.00

Skidtubes

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod A/RAluminum Rod *midway*

*BE 12/02/21*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

*SAD 12-02-21*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

*DP 12-2-21*

4- Install nut plate as per dwg

*SAD 12-02-21*

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*Pl 12-02-21*

*1x* *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 79654

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February-01-12 11:23:52 AM

Item ID: D206-642-341

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 QC5- Inspect part completeness to step on W/O 0.00

**\*180\***

QC Memo 0.00

Quality Control

W 12-02-22 (1)

190 Pressure Wash per QSI005 4.3 0.00

**\*190\***

HandFinish Memo 0.00

Hand Finishing Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 20/m Feb. 23/2012

205 0.00

**\*205\***

SprayPaint Memo 0.00

Spray Painting

PRIME B 118319  
DELFLEET BLUE B 118395  
CLEAR DELFLEET B 118093

AB 12-3-7

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79654****\*79654\***

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February-01-12 11:23:52 AM

Item ID: D206-642-341

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

215

QC14- Inspect Spray Paint

0.00

**\*215\***

QC

Memo

0.00

5.2/03/06

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 79654****\*79654\***

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February-01-12 11:23:52 AM

Item ID: D206-642-341

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00

**\*220\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291

Sikaflex expiry date:

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291

Sikaflex expiry date:

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch:

IX Ø m / 12/03/16

M120125



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Work Order ID 79654

**\*79654\***

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Item ID: D206-642-341

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230 QC3- Inspect Part Finish 0.00

**\*230\***

QC Memo 0.00

Quality Control

*IX BL 123-19*

240 QC5- Inspect part completeness to step on W/O 0.00

**\*240\***

QC Memo 0.00

Quality Control

*1 BL 123-19*

250 Packaging 0.00

**\*250\***

Packaging Memo 0.00

Packaging Identify and pack for shipping as per PPP D206-642-341

Location: *PPP 79639*  
PPP Rev: \_\_\_\_\_

*6/2/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*N900040100\***Setup Start **\*NS1\***

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Stop **\*NS2\***

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Start Date: 31/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

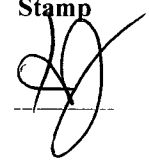
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

12/3/22 mf  
12-03-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## February-01-12 11:23:56 AM

**\*79654\***

**\*D206-642-341\***

**Required Date:** 27/03/2012

**Required Qty: 1.00**

**Comments:** IPP Rev: H05.10.11 Added D3429-1 per CHG004KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000		1			X
*AN960JD416*									**	1		M-12/03/16	
Washer													
CCR264SS3-3		Purchased	No				Each	867.0000		2			
*CCR264SS3-3*									**	SAD		12-02-21	
Cherry Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST331			867						
					113973		2						
					117849		135						
					119017		730			2			
CR3212-4-03		Purchased	No				Each	1,632.000		2			
*CR3212-4-03*									**	SAD		12-02-21	
Cherry Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FP002			642						
					114859		642			2			
				ST331			990						
					110139		2						
					119017		988						

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

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Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2620 Manufactured No

Each 58.0000

1

**\*D2620\***

Skidtube, 206 Skidtube

*B79545*

**\*\***

*①*

*CF 12.2.16*

Location

Loc Qty

Loc Code

LG

58

71617

2

76820

6

77996

10

77999

10

78000

10

79542

10

79543

10

D2647 Manufactured No

Each 120.0000

1

**\*D2647\***

Cap

**\*\***

*BE 12/02/16*

Location

Loc Qty

Loc Code

LG002

120

73826

12

75482

108

*1*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign. & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 3

February-01-12 11:23:56 AM

Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

731.0000

19

**\*D2649\***

Cross Bolt Spacer

**\*\***

*BE 12/02/21*

Location

Loc Qty

Loc Code

LG

415

77574

15

78019

400

LG001

316

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

197

D2654-5

Manufactured No

Each

4.0000

1

**\*D2654-5\***

Web

**\*\***

*SAD 12-02-17*

Location

Loc Qty

Loc Code

LG

4

78832

4

*B80057*

*(1)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-01-12 11:23:56 AM

Page 4

Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

101.0000

1

**\*D2680-041\***

Nut Plate

\*\*

SAD 12-02-21

Location

Loc Qty

Loc Code

ST013

5

75479

5

ST019

96

76790

96

Each

1,542.000

56

MS27039C1-08

Purchased

No

**\*MS27039C1-08\***

SCREW

\*\*

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST292

1000

120308

1000

ST293

541

116373

3

118077

14

118159 ✓

412

119309

112

220

Each

2,033.000

54

54

ALS4-1032-130

Purchased

No

**\*ALS4-1032-130\***

Insert

\*\*

Location

Loc Qty

Loc Code

ST280

944

119084

944

ST281

1089

119632

89

120410

1000

120181

54

February-01-12 11:23:56 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February-01-12 11:23:56 AM

Page 5

Work Order ID: 79654

\*79654\*

Parent Item: D206-642-341

\*D206-642-341\*

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

220

Each

0.0000

54

54

m-l 12/03/16 \*

\*AN960C10I \* 120648

washer

\*\*

54

AN960JD10L NAS1149D0332J Purchased No

220

Each

0.0000

2

2

m-l 12/03/16 \*

\*AN960.ID10I \*

Washer

\*\*

2

D2646 Manufactured No

220

Each

74.0000

1

1

m-l 12/03/16 \*

\*D2646\*

Aft Cap

\*\*

## Location

## Loc Qty

## Loc Code

FP002

74

62678

5

68280

5

70945

1

71070

2

73294

1

73825

60

78018

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February-01-12 11:23:56 AM

Page 6

Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

220 Each

705.0000 14 14

**\*D2651-1\***

Plug

79234

\*\*

M-L 12/03/16

Location	Loc Qty	Loc Code
FP001	699	
57869	1	
66445	10	
69018	2	
70827	2	
70839	8	
71037	11	
72864	25	
73827	23	
78584	317	
FP-A	6	
77559	22	
78124	284	

14

D2651-3 Manufactured No

220 Each

2,383.000 14 14

**\*D2651-3\***

O-Ring

\*\*

M-L 12/03/16

Location	Loc Qty	Loc Code
FP001	383	
61962	12	
73828	371	
FP-A	2000	
78126 ✓	2000	

14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-01-12 11:23:56 AM

Work Order ID: 79654

\*79654\*

Parent Item: D206-642-341

\*D206-642-341\*

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220 Each

14.0000 1 1

\*D3535-11\*

Wearshoe

\*\*

m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

14

70879

1

71284 ✓

13

D3535-23

Manufactured No

220 Each

29.0000 1 1

\*D3535-23\*

Wearshoe

\*\*

m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

29

73314 ✓

18

74508

11

D3535-35

Manufactured No

220 Each

14.0000 1 1

\*D3535-35\*

Wearshoe

\*\*

73311

m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

14

67598

1

70815

1

74509

12

D3536-11

Manufactured No

220 Each

10.0000 1 1

\*D3536-11\*

Gasket

\*\*

80006

m-l 12/03/16

Location

Loc Qty

Loc Code

FP002

10

46649

1

46715

4

65574

1

71283

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-23

Manufactured No

220 Each

28.0000 1 1

**\*D3536-23\***

Gasket

\*\*

*M-L 12/03/16*

Location

Loc Qty

Loc Code

FP002

28

43406

1

73312 ✓

15

74510

12

D3536-35

Manufactured No

220 Each

25.0000 1 1

**\*D3536-35\***

Gasket

\*\*

*M-L 12/03/16*

Location

Loc Qty

Loc Code

FP002

25

73313

7

74511 ✓

18

D3537-1

Manufactured No

220 Each

33.0000 6 6

**\*D3537-1\***

Wearpad

\*\*

*79834*

*6 M-L 12/03/16*

Location

Loc Qty

Loc Code

FP002

33

69817

5

77560

28

D3537-3

Manufactured No

220 Each

30.0000 1 1

**\*D3537-3\***

Wearpad

\*\*

*M-L 12/03/16*

Location

Loc Qty

Loc Code

FP002

30

74500

25

76986

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February-01-12 11:23:56 AM

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Work Order ID: 79654

**\*79654\***

Parent Item: D206-642-341

**\*D206-642-341\***

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

255.0000

1

1

**\*MS27039-4-06\***

Screw

**\*\***

*m-1 12/03/16*

Location

Loc Qty

Loc Code

ST292

255

119075

255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW *
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SKIDTUBE  
RETURN TO  
1 NOV 1997  
UNCONTROLLED  
SUBJECT TO  
NO 79654 M.L.J  
12/02/01

RELEASED  
08-07-23-17

REV.	DESCRIPTION	BY	DATE
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCRP. DEC9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AdS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 1 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

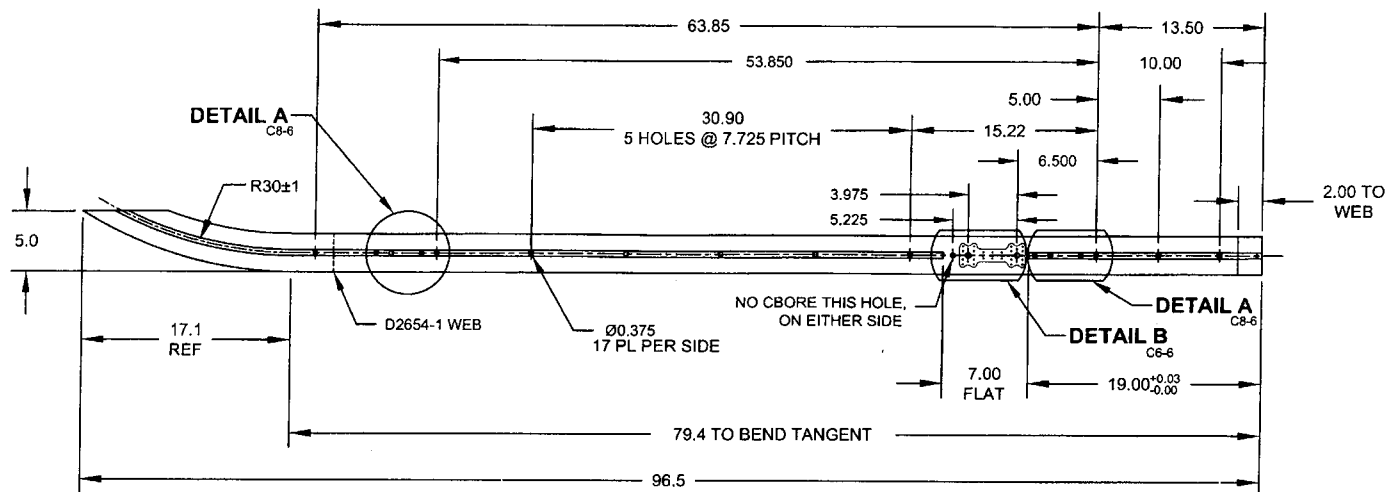
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

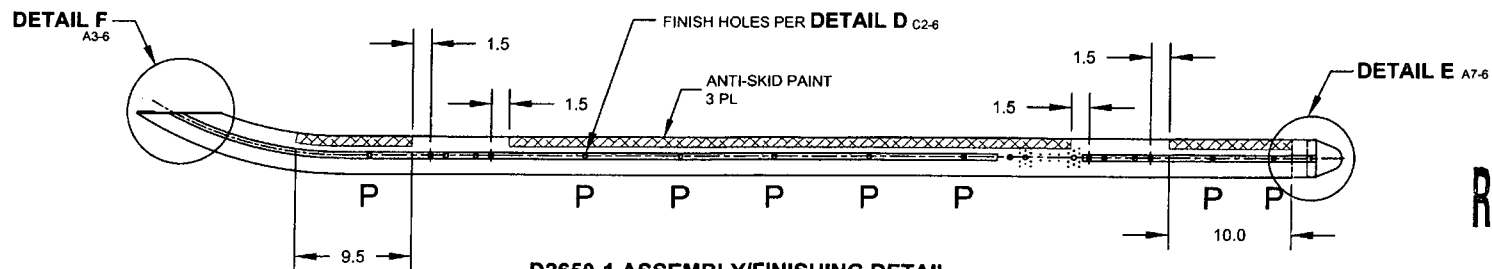
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79654



**D2650-1 BENDING/DRILLING DETAIL**



**D2650-1 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
68 07 22 1118

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1967 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

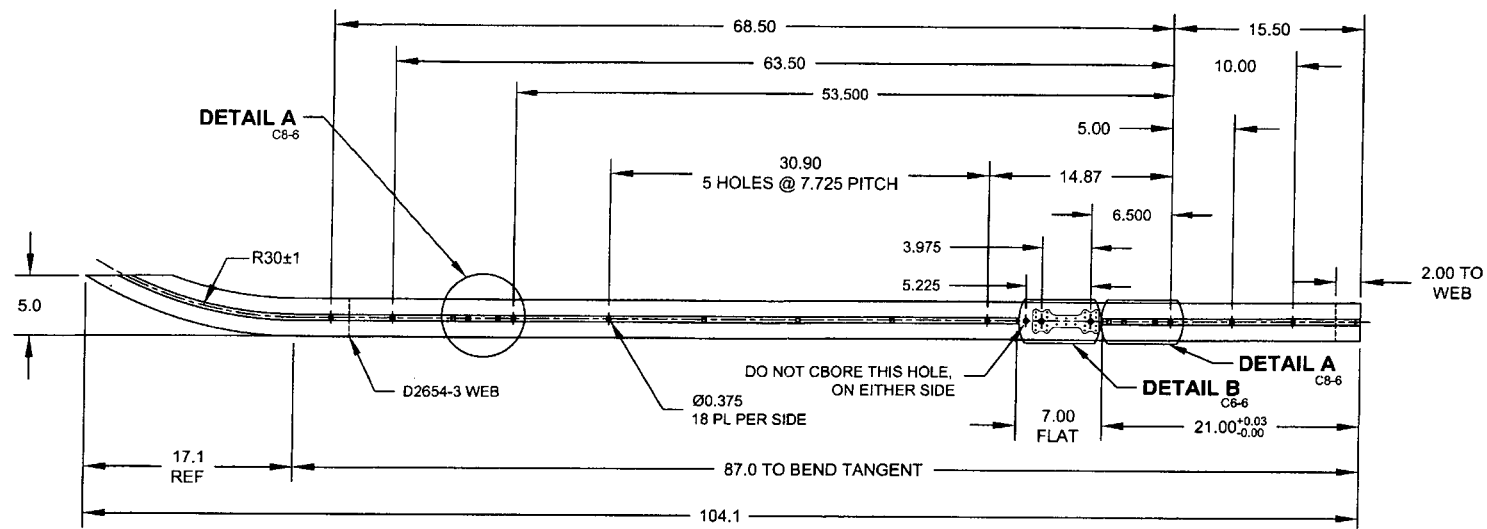
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

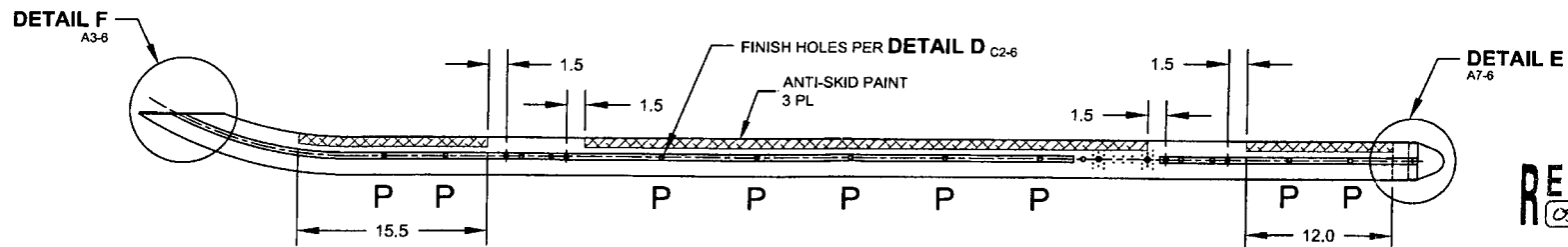
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79654



**D2650-3 BENDING/DRILLING DETAIL**



**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
08-07-22-118

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

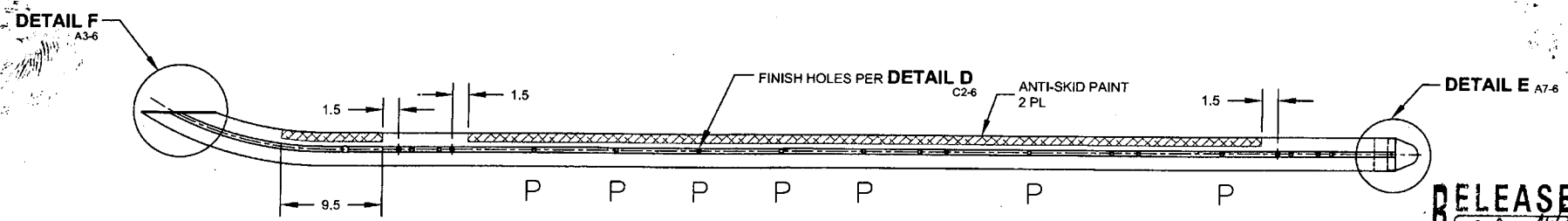
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Technical drawing of a bridge deck cross-section. The drawing shows a horizontal profile of the deck with various dimensions and details. Key features include:

- Dimensions:**
  - Overall width: 92.25
  - Distance from centerline to outer edge: 43.63
  - Distance from centerline to inner edge: 35.90
  - Distance from centerline to hole center: 28.18
  - Distance from hole center to outer edge: 17.950
  - Distance from hole center to inner edge: 10.23
  - Distance from centerline to hole center: 30.90
  - Distance from centerline to hole center: 82.250
  - Distance from centerline to hole center: 92.25
  - Distance from centerline to hole center: 6.00
  - Distance from centerline to hole center: 2.00 TO WEB
  - Distance from centerline to hole center: 2.500
  - Distance from centerline to hole center: 2.500
  - Distance from centerline to hole center: 100.3 TO BEND TANGENT
  - Distance from centerline to hole center: 117.4
  - Distance from centerline to hole center: 17.1 REF
- Details:**
  - DETAIL A C8-6:** Two circular details are shown, one on the left and one on the right, both labeled "DETAIL A C8-6".
  - R30±1:** A curved section on the left side of the deck.
  - 5 HOLES @ 7.725 PITCH:** A series of five holes along the centerline.
  - Ø0.375 19 PL PER SIDE:** A hole with a diameter of 0.375 and 19 plates per side.
  - Ø0.625 THIS LOCATION ONLY BOTH SIDES:** A hole with a diameter of 0.625, located at the centerline on both sides.
  - D2654-5 WEB:** A section of the deck labeled "D2654-5 WEB".



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MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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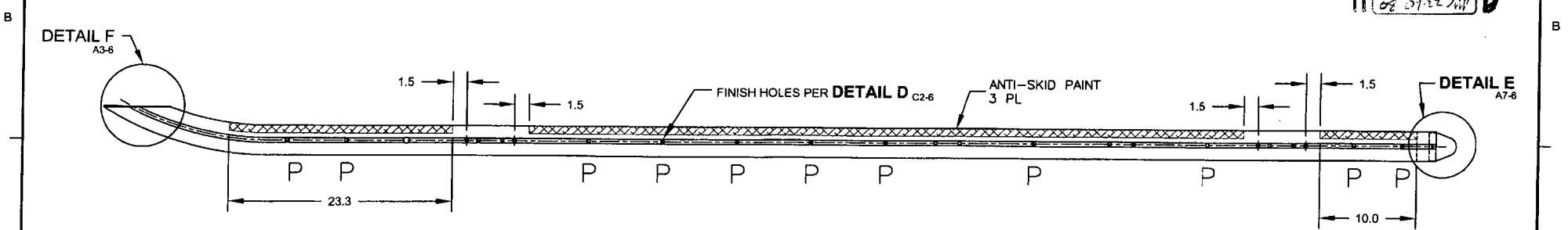
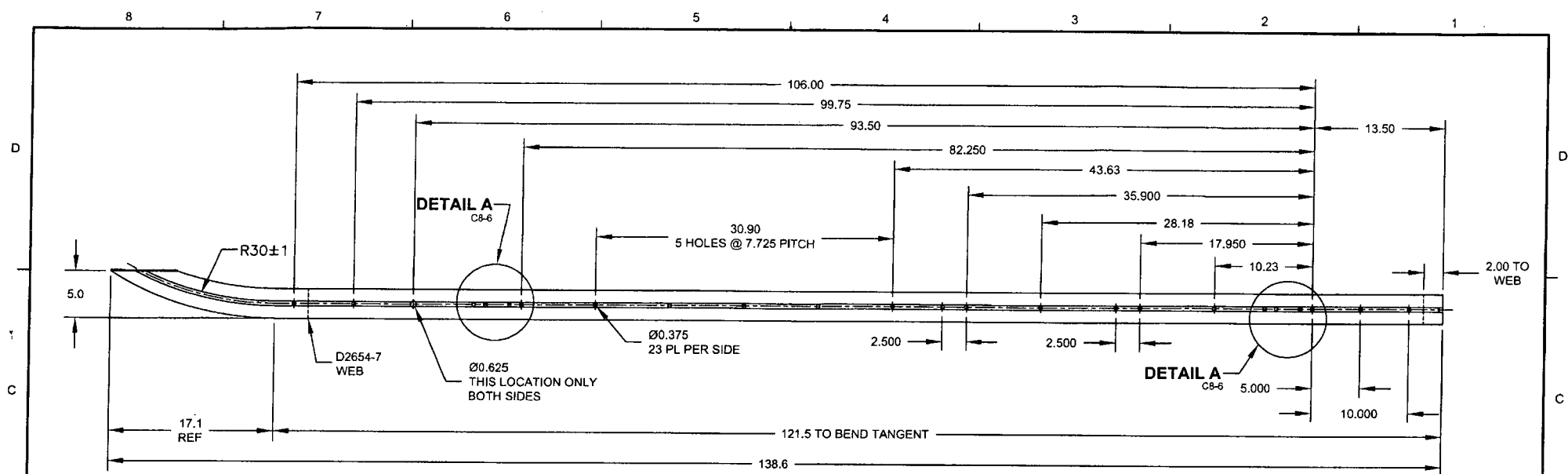
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**NOTE:** Date & initial all entries

79654



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02 0722/117

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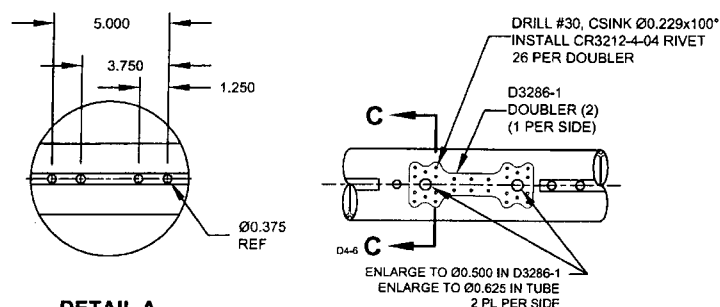
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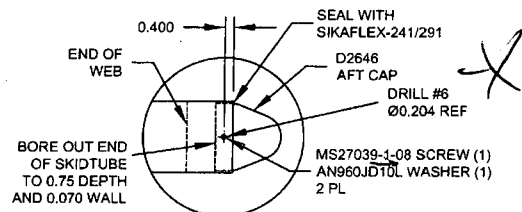
**NOTE:** Date & initial all entries

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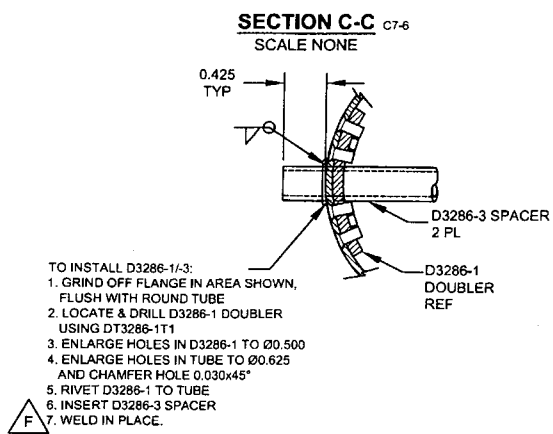


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

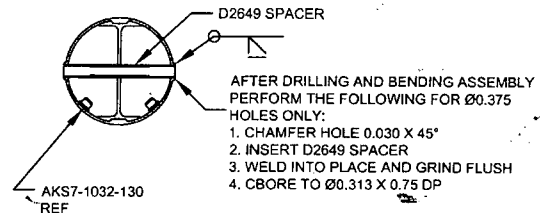
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



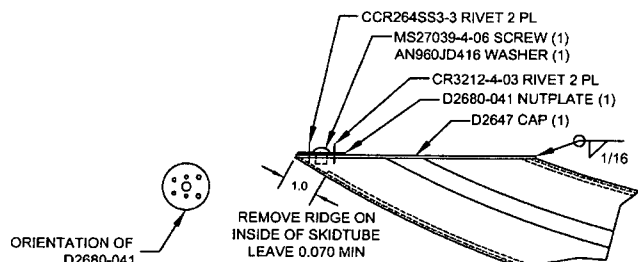
**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.





**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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08-09-22-19

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